

Work Order ID 64457

Monday, December 06, 2010 10:22:21 AM



Page 1

Item ID: D2803-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/6/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-12-06 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2803 | Rev B | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

6061 .500 x 10"

1-Cut as per Pte d2803-2

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

12-12-13

⑥

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA102

amk 10/12/15

⑥ 12-12-13

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

amk 10/12/15

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 64457

Monday, December 06, 2010 10:22:21 AM



Page 2

Item ID: D2803-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/6/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



M.A 10/12/15

0.00

QC

Memo

Quality Control

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



0.00

HandFinish

Memo

Hand Finishing

ml 10 12 15 (6)

145

QC3- Inspect Part Finish

0.00



0.00

QC

Memo

Quality Control

6 bh 10-12-15.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 64457

Monday, December 06, 2010 10:22:21 AM

Page 3

Item ID: D2803-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 12/6/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

9510/12/20 (6)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/2010
MP
10-12-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:22:25 AM

Page 1

Work Order ID: 64457



Parent Item: D2803-2



Parent Item Name: Bracket

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 00.11.06 New Issue EC
IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM
IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC IPP
Rev:D add qc3 DD 10.02.19 Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.500X10.00 0 | | Purchased | No | | | 100 | f | 40.0000 | 1.9167 | 12.10547 | | | |



6061-T6 Bar .500 x 10.00



12-12-13

Location

Loc Qty

Loc Code

MAT05

40

111382

28

112764

12

111382

6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 64457 |
| Description: Bracket | | Part Number: D2803-2 |
| Inspection Dwg: D2803 | Rev: B | Page 1 of 1 |

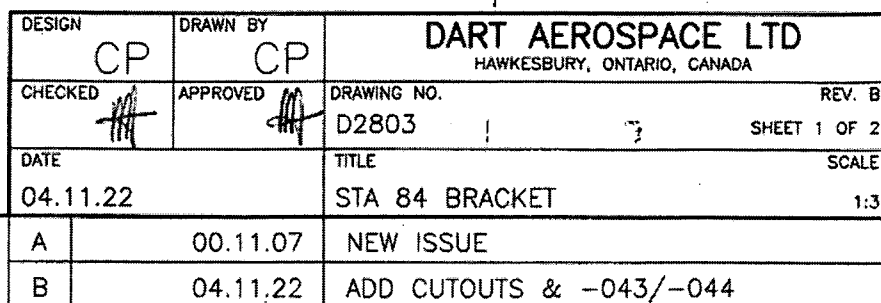
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.757 | +0.005/-0.000 | Ø.760 | — | | Micr | ML-01 |
| 1.420 | +/-0.001 | 1.420 | — | | Vern | ML-7 |
| Ø0.191 | +0.005/-0.000 | Ø.193 | — | | " | " |
| Ø0.507 | +0.000/-0.001 | Ø.5062 | — | | Micr | ML-01 |
| Ø0.507 x 0.250 | +0.000/-0.001 | Ø.5064 x .253 | — | | Micr | ML-01 |
| 12.411 | +/-0.010 | 12.411 | — | | M-type | ML-2 |
| 6.933 | +/-0.010 | 6.933 | — | | " | " |
| 0.250 | +/-0.010 | .249 | — | | Vern | ML-7 |
| 0.875 | +0.000/-0.001 | .8746 | — | | Micr | ML-01 |
| 0.250 | +0.000/-0.005 | .246 | — | | Depth gage | ML-05 |
| 0.125 | +/-0.010 | .123 | — | | Vern | ML-7 |
| 0.125 | +/-0.010 | .124 | — | | " | " |
| 0.500 | +/-0.010 | .501 | — | | " | " |
| 0.125 | +/-0.010 | .126 | — | | " | " |
| 0.188 | +/-0.010 | .189 | — | | " | " |
| 0.562 | +/-0.010 | .563 | — | | " | " |
| 0.125 | +/-0.010 | .126 | — | | " | " |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

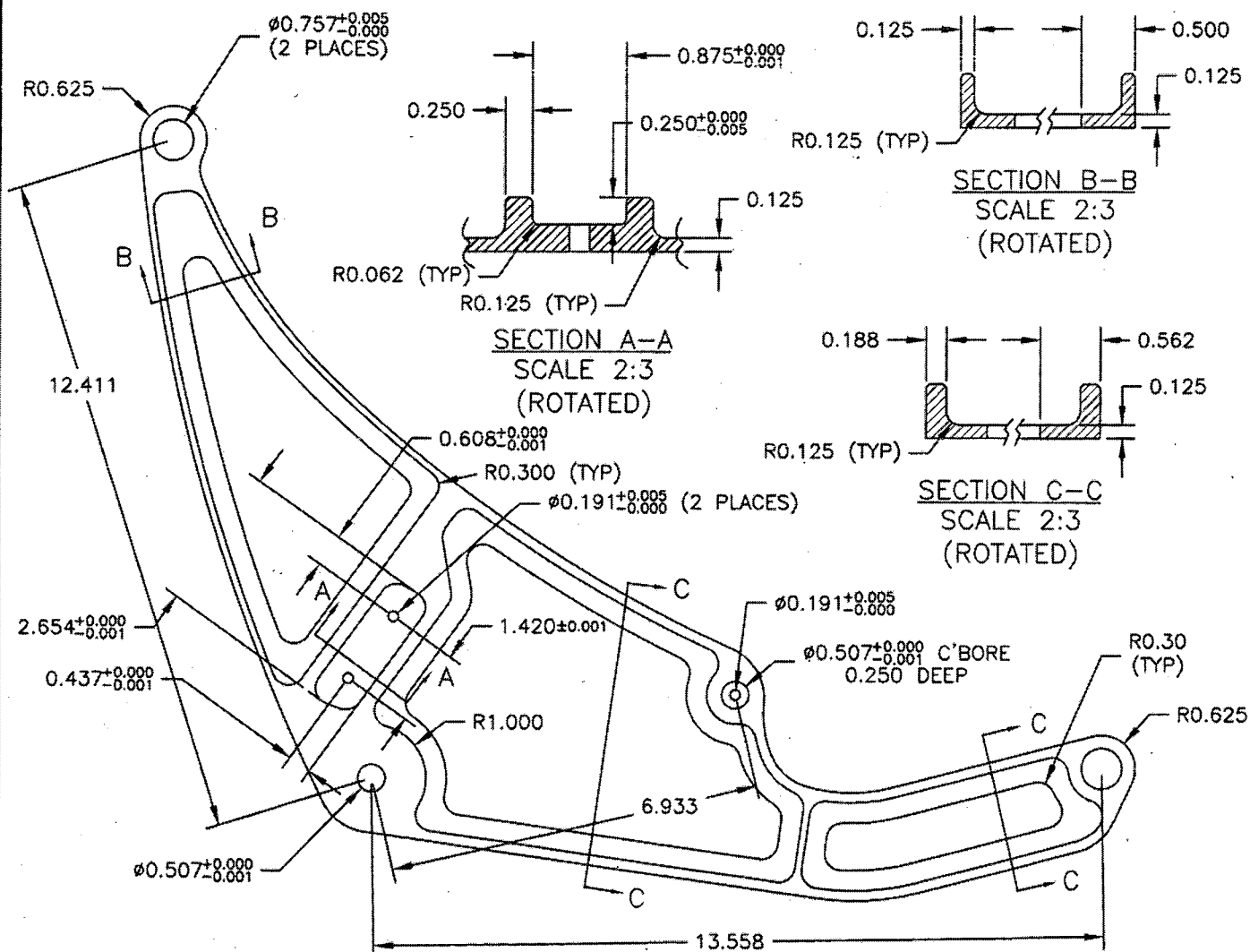
| | | | |
|-------------------------------|-------------------------------|----------------------------|-----|
| Measured by: <i>ML</i> | Audited by: <i>A.A</i> | Prototype Approval: | N/A |
| Date: 10/12/14 | Date: 10/12/14 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------------------------|------------|--------------------|
| A | 05.04.25 | New Issue | KJ/JLM | |
| B | 06.12.07 | 13.558 dimension removed | KJ/JLM | |
| C | 08.01.16 | Tolerance revised for 0.875 dimension | KJ/EC/DD | <i>[Signature]</i> |



RELEASED

05.03.11



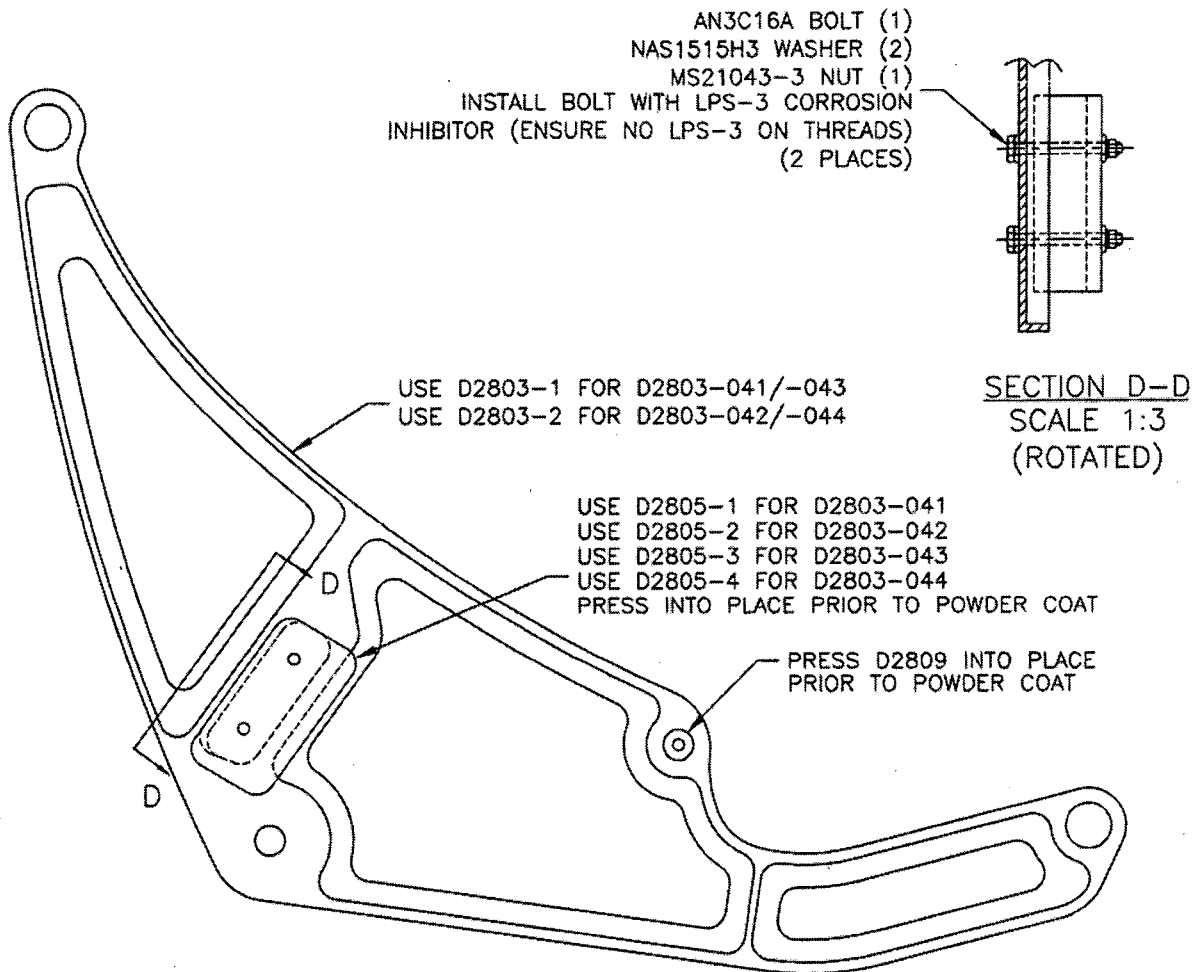
1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2803 | REV. B SHEET 2 OF 2 |
| DATE 04.11.22 | | TITLE STA 84 BRACKET | SCALE 1:3 |



64457

RELEASED

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.